

Date: Tuesday, 05/02/2008 10:51:45 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARSHOE
<b>Job Number</b> :	37212		
<b>Estimate Number</b> :	12786		
<b>P.O. Number</b> :		<b>Part Number</b> :	D35645
<b>This Issue</b> :	05/02/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3564 REV D
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36338	<b>Drawing Revision</b> :	D
	<b>Type</b> :	<b>Material</b> :	
	SMALL / MED FAB	<b>Due Date</b> :	15/02/2008
<b>Written By</b> :		<b>Qty:</b>	30
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est Rev: A New Issue 07-03-08 ec Est Rev: B As per Rev C 07-07-09 JLM Est Rev: C As per Rev D 07-09-09 JLM Verified By: EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 .063 Sheet
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**Comment:** Qty.: 1.2684 sf(s)/Unit Total: 38.0520 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: 106860 IB 8-2-6

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: D

Prog Rev: D

IB 8-2-6

2-Deburr if necessary

IB 8-2-2

(33)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-2-6

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

6 08/02/07 (counts) 733

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT and DT

8155

8179

EP 08/02/20 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 08/01/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/02/2008 10:51:45 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37212

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

6.0

QC5

INSPECT WORK TO CURRENT STEP



*John 20 33*



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0

POWDER COATING

POWDER COATING



*M106442*



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*08-02-20*

*(X33)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*(33)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BR 08-02-20*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FR-18*

*BR 08-02-20*

*(33)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*(33)*

Comment: FINAL INSPECTION/W/O RELEASE

*08/02/20*

Job Completion



*2008/2/20*

*(33)*

*W*

**Dart Aerospace Ltd**

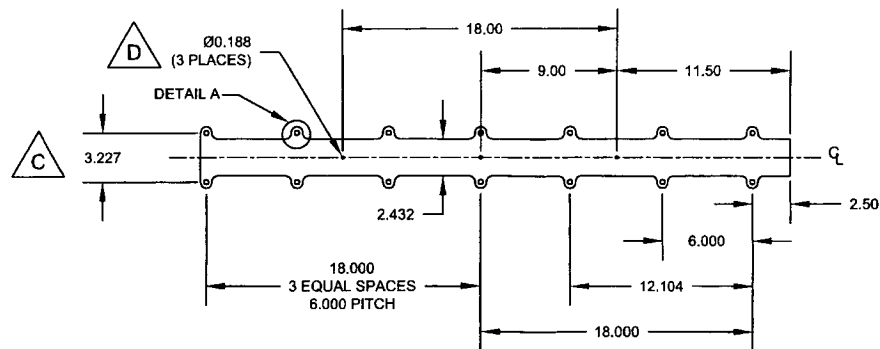
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

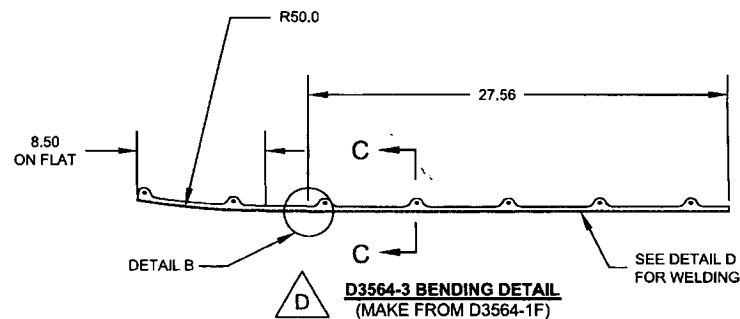
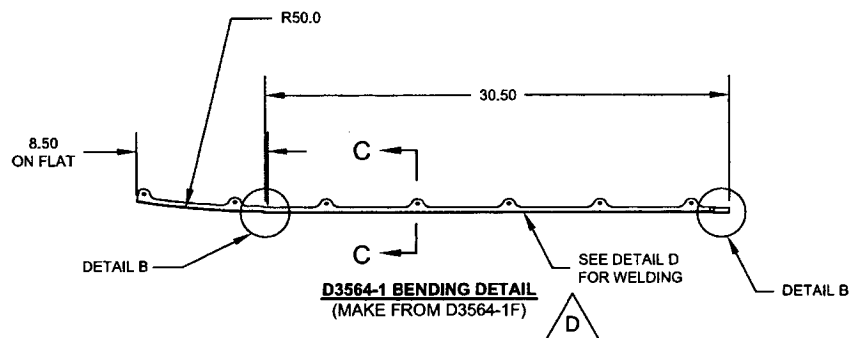
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\bar{C}$

*W/027212*

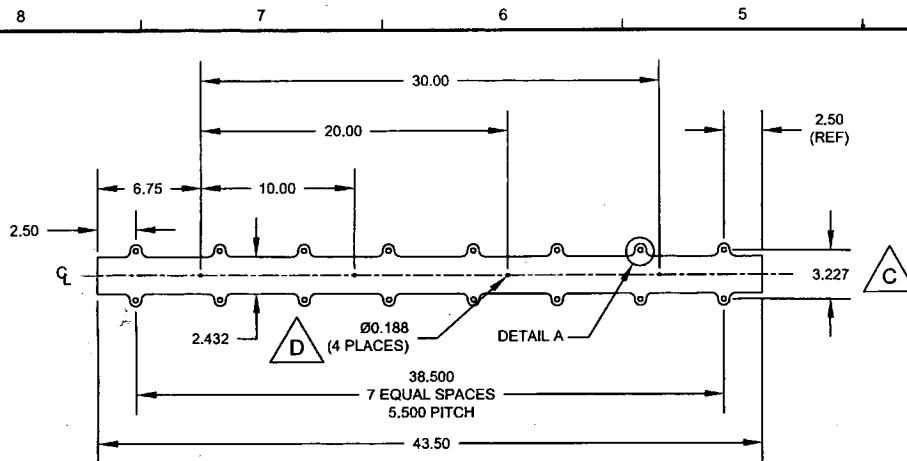
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

**RELEASED**

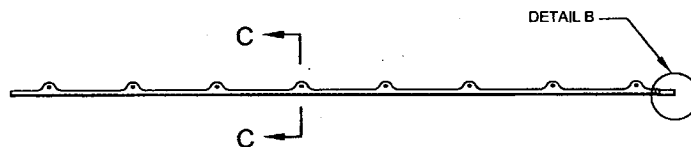
07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

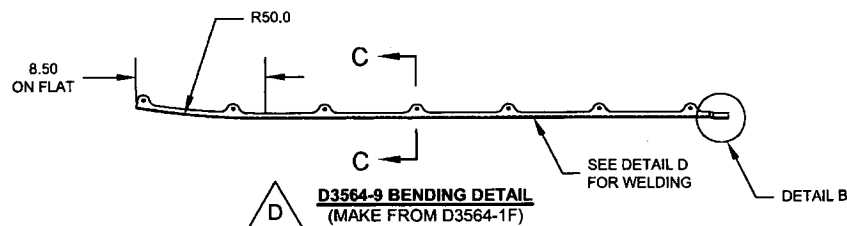
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3564	REV. D SHEET 1 OF 3
TITLE WEARSHOE	SCALE 1:8
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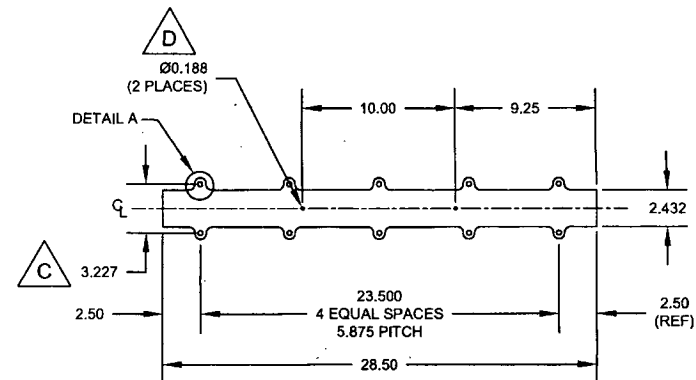
**D3564-5F FLAT PATTERN**



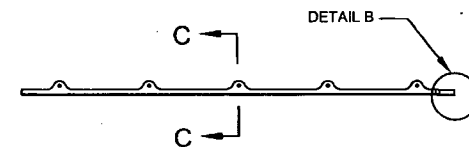
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



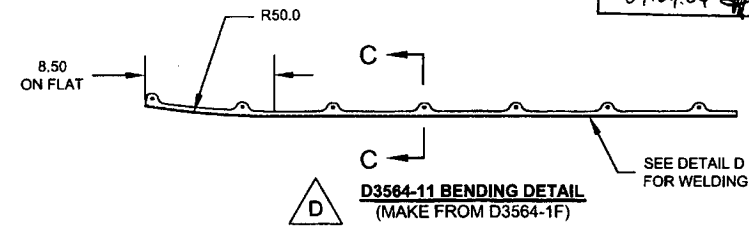
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



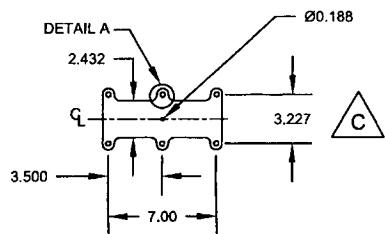
**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED

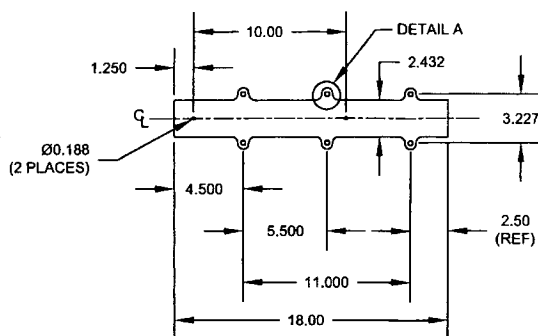
07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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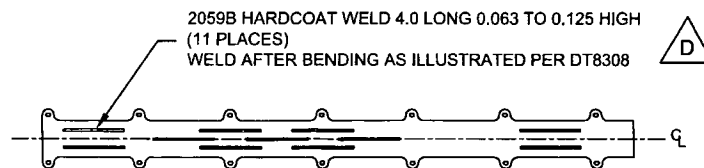
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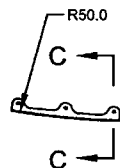
**D3564-13F FLAT PATTERN**



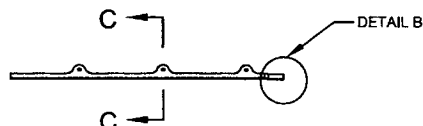
**D3564-15F FLAT PATTERN**



**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



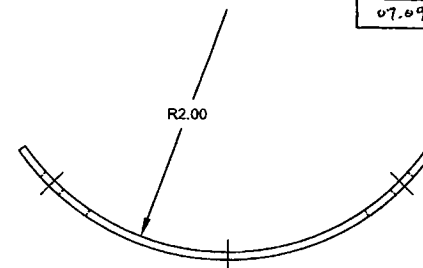
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



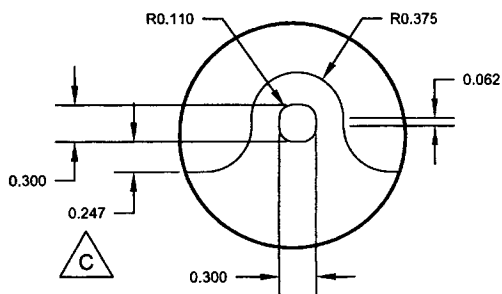
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

**RELEASED**

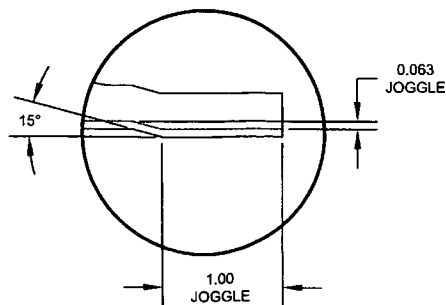
07.09.04



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
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8 7 6 5 4 3 2 1

